



Job Qty: 50 pcs



Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Plex 1/28/20 3:16 PM Dart.lajeunesse.marie

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
130 QC 6	50 pcs	2/26/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS 81 9-89
				QC 6 - 61	DAS 82 9-89
				QC 6 - 40	
				QC 6 - 81	FEB 12 2020
170 Packaging 3-1 - Stock - B4B	50 pcs 22 Pcs	2/26/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST520 DAS 80 9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	FEB 13 1 9-89
				Packaging 3 - 6 - B4B	FEB 13 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	50 pcs 22 Pcs	2/26/20	0.00 0.00	QC 21 - SA - 21 ✓	ST520
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS 21 FEB 13 2020

Part Op 110 - (Purchasing) Issue P/O to Metec : H604571B Manufacture as per dwg C of C is required

Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) ENSURE C OF C IS ATTACHED

130 - (QC6- All purchased or subcontracted products)

170 - (Identify as per dwg & Stock Location: _____)

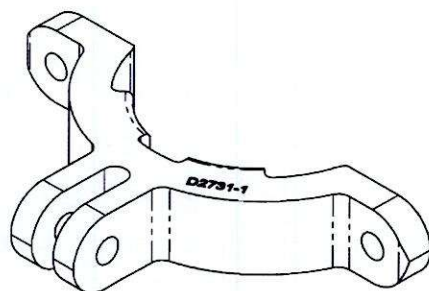
180 - (QC21- Final Inspection - Work Order Release)

x 50 Pcs 28 Jan 2020

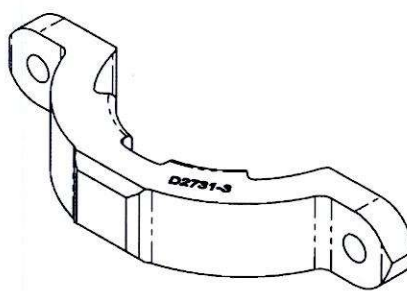
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2423	Lug Extrusion	3.4150 ft (.0683 ea)	110-Purchasing	5141186	
D2731-7P	Lug	50 pcs (1 ea)	110-Purchasing	5252339	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Purchasing	D2423	3	608	0	
	D2731-7P	50	0	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches ± 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches ± 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches ± 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches ± 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches ± 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches ± 0.010	0.385 0.365		
7	Mounting Lug	0.750Inches ± 0.010	0.760 0.740		
8	Mounting Lug	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Mounting Lug	0.100Inches ± 0.010	0.110 0.090		
10	Mounting Lug	45.000Degrees ± 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	

Plex 1/28/20 3:16 PM Dart.lajeunesse.marie

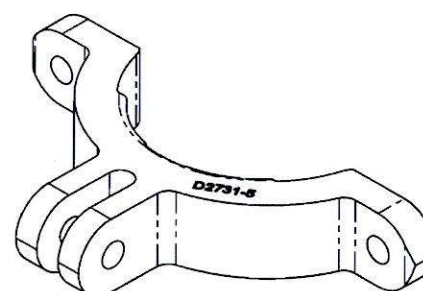
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2001-28



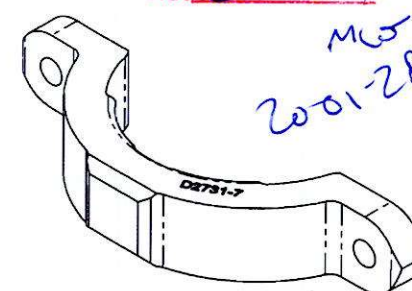
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED

NOTES:

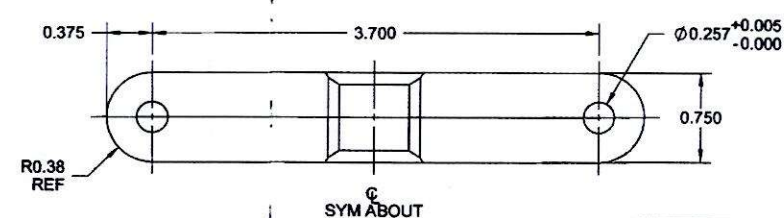
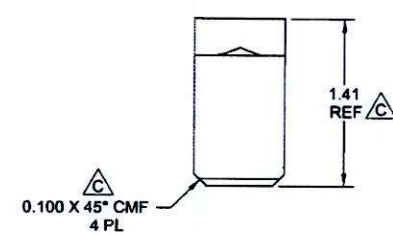
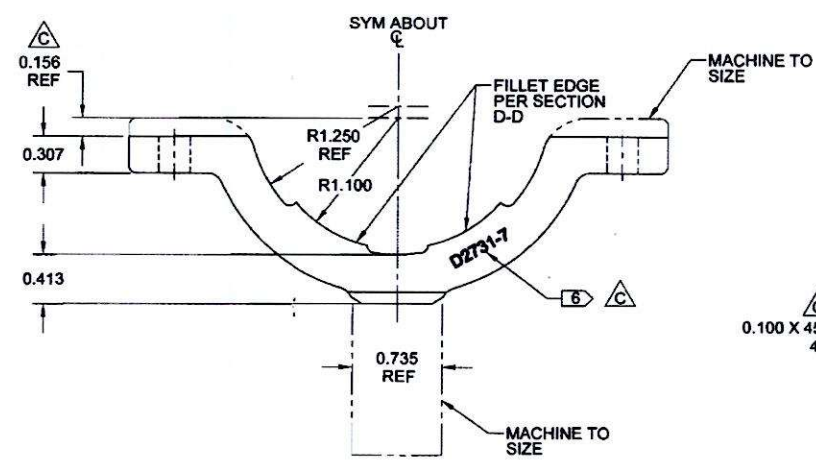
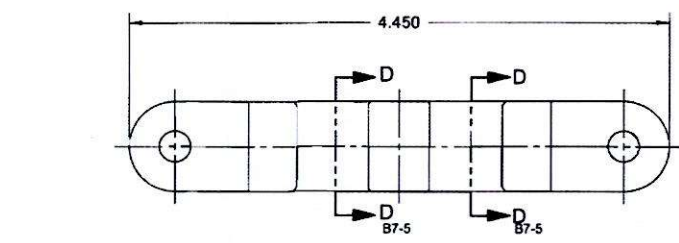
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SECTION D-D D4-5
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

**DEO ATTACHED
RELEASED**
09/06/25/19

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045718



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Waiz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045718

PO Date: 1/28/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206276	D2731-7P	D2731 Rev.C			Lug : Various STC's receive pcs	Firmed -		2/4/20	50 pcs	0 pcs	50 pcs	\$16.20/pcs	\$810.00
													Grand Total:	\$810.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 1/28/20 4:01 PM dart.lussier.patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 26619
Shipment Date: 28-Jan-2020
Ship Via: Pick up at METEC
Order Number: 4571
Order Date: 01/28/2020

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB045718
Terms: Net 60 Days

----- Quantity -----								
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number
1	50	50	0	0	EA	DART-D2731-7P Lug alodined and painted as per QSI005	C	4571-01

DAS
82
9-89

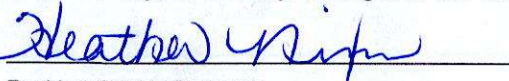
FEB 04 2020

RECEIVED

JAN 30 2020

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.



Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
50	D2731-7	Lug	C	S141186	018942-1	HB045718

DAS
32
9-89

FEB 04 2020

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, January 29, 2020

Entered: _____ Date: FEB 05 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: 206276 Part No. D2731-7	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☒ Quality ☐																															
Date: FEB 05 2020	Sequence #: QC 6	QTY Affected: 27 out of 50		MRB (QSI042)																													
Description Work Order Deviation		Disposition		DAS Completed By 82 9-89 FEB 05 2020 Lead hand / Supervisor QC / QA Coordinator																													
PAINT THICKNESS IS TOO MUCH , WE MEASURED .030" IN SOME AREAS WITH THE PosiTest DFT Coating Thickness Gauge. WE REJECTED ALL PARTS WHERE THE A .250 DIA. BOLT DIDN'T GO FREELY THROUGH THE HOLES (DIA. .257 +.005 -.000). DAS 82 FEB 05 2020 9-89		<i>Ref only</i> <i>Rework done on</i> <i>-A work order</i> <i>DD 20-02-12</i>																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☒ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☒ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☒ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																																	